

Work Order ID 152701

152701

Page 1

Friday, November 04, 2016 1:34:11 PM

Item ID: D4038-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle Assy Fwd LH
 Start Date: 11/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/9/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: dm Date: 16/11/4 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	E								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.03							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.06							
Small Fab	Assemble as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 16/11/8 AUTH dmRELEASED 9 DATE 17.01.14

9-89

PTD

send for test fit.
do not paint - see Sian

DAS
6
9-89

NOV 08 2016

NOV 24 2016

1 FF

DAS
38
9-89

NOV 24 2016

DQA: Just Date: 2017-02-16

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 152701 Date: FEB 15 2017Work Order update only ☐

Work Order: <u>152701</u> Part No. <u>D4038-041</u> NCR No. <u>17-6282</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☒ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>17-02-24</u>		Step #: <u>120</u>		QTY Effective: <u>①</u>			MRB (QSI042) Approval DAS <u>9</u> 9-89 <u>170124</u> Completed By <u>BEB 2017</u> <u>17.02.02</u>		
Description Work Order Deviation				Disposition				Lead hand / Supervisor Approval Verification <u>① 17-02-03</u>	
part use for test fit, damage found from installation				Remove D4038-9/D4038-5 buff out marking abline continue work from seg 110 add new hardware				QC / QA Coordinator Approval <u>① 17-02-03</u>	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☒ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mis-labeled ☒ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐					
OTHER: _____									

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
121 *121* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo ***MASK INTERIOR OF BLOCKS AND MASK ALL HOLES WITHOUT BOLTS** START TIME: 10:05 OVEN TEMPERATURE: 320 FINISH TIME: 10:35	0.00 0.01				1	0	1702-2	DAS 34 3-89
122 *122* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			DAS 36 3-89 FEB 02 2017
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: ST Memo	0.00 0.00				1			DAS 21 3-89 FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89	DAS 21 9-89		
140									
QC	Memo	0.02							FEB 03 2017
Quality Control							DAS 21 9-89		FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																									

Picklist Print

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Work Order ID: 152701

152701

Parent Item: D4038-041

D4038-041

Parent Item Name: Angle Assy Fwd LH

Start Date: 11/7/2016

Required Date: 11/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC IPP
Rev:B 11.01.31 as per dwg rev.c DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4038-1 *D4038-1* Angle, Fwd, LH		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST512		1							
				144137		1							
D4038-5 *D4038-5* Block		Manufactured	No			100	Each	0.0000	1	1			
								B 152706	**				
D4038-9 *D4038-9* Block		Manufactured	No			100	Each	3.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st073		3							
				148059		3							
AN3-14A *AN3-14A* Bolt		Purchased	No			100	Each	122.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				over003		80							
				m134852		0							
				m135600		30							
				m135966		50							
				ST349		42							
				m134852		3							
				m135056		39							

DAS
6
9-89

NOV 08 2016

DAS
30
9-89

NOV 24 2016

DAS
6
9-89

NOV 08 2016

DAS
6
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Picklist Print

Friday, November 04, 2016 1:34:10 PM

Page 2

Work Order ID: 152701

152701

Parent Item: D4038-041

D4038-041

Parent Item Name: Angle Assy Fwd LH

Start Date: 11/7/2016

Required Date: 11/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

1,665.000

2

2

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

216

m134360

108

m135135

108

OVER007

600

m135945

600

ST303

842

m135530

239

m135600

3

m135767

600

NOV 08 2016
DAS
6
9-89

NAS1149D0363J

Purchased

No

100

Each

1,172.000

4

4

NAS1149D0363J

Washer

Location

Loc Qty

Loc Code

GA

336

m134055

336

ST263

836

m135864

836

NOV 08 2016
DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

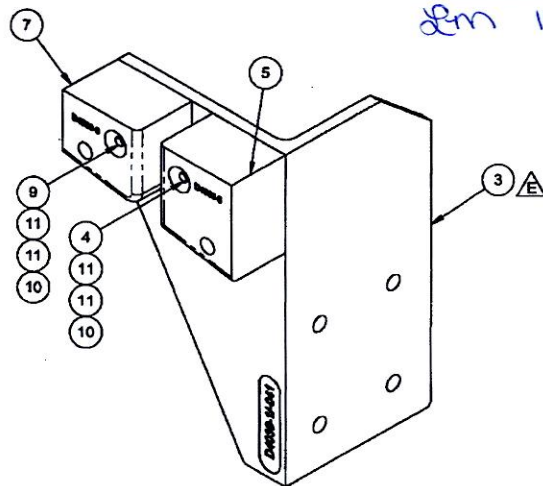
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																													
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ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D4038-041	ANGLE ASSEMBLY, FWD, LH
2		X	D4038-042	ANGLE ASSEMBLY, FWD, RH
3	1		D4038-1	ANGLE, FWD, LH
4		1	D4038-2	ANGLE, FWD, RH
5	1		D4038-5	BLOCK
6		1	D4038-6	BLOCK
7	1		D4038-9	BLOCK
8		1	D4038-10	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)

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WITHOUT NOTICE
WORK ORDER
NO. 152701

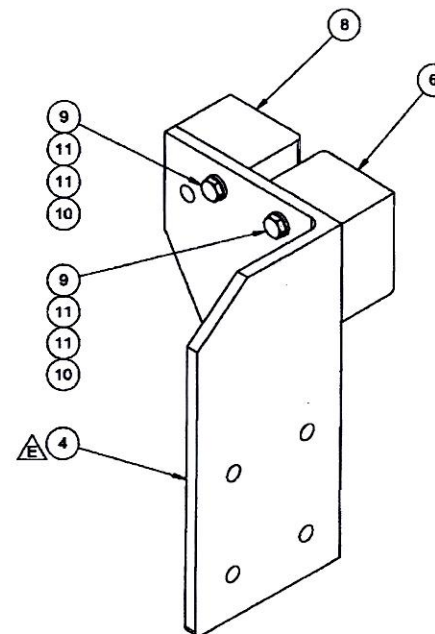
2m 16/11/4



D4038-041 ANGLE ASSEMBLY, FWD, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041 - 1.75 lbs
-042 - 1.74 lbs



D4038-042 ANGLE ASSEMBLY, FWD, RH

RELEASED
2011-04-21
WAB

E	1.19 X 1.00 CHAMFER WAS R1.00. REF: NCR11-543.	MB	11.04.11
D	REVISED D4038-7/8-11/12 AS FOLLOWS: 1.87 WAS 1.73 (C7-9); 2.14 WAS 2.00 (C4-9); 2.13 WAS 2.00 (C7-10); 1.86 WAS 1.73 (C4-10); 1.52 WAS 1.38 (C7-13); 1.79 WAS 1.85 (C4-13); 1.77 WAS 1.85 (C7-14); 1.49 WAS 1.38 (C4-14). REASON: NCR11-456.	MB	11.03.03
C	REVISED D4038-3/4 AS FOLLOWS: 0.589 WAS 0.714 (B2-5, B4-6); D4038-043/044 ARE AFFECTED. REASON: NCR11-399.	MB	11.01.20
B	REVISED DIMENSIONS ALL SHEETS, ADD Ø0.316 HOLES IN -1/2-3/4 PARTS, ADD RADIUS TO -1/2-3/4 PARTS	HS	10.01.05
A	NEW ISSUE	HS	08.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4038 BRACKET COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	REV. E SHEET 1 OF 14 SCALE NTS	
DATE	11.04.11		